

Date: Monday, 09/02/2009 4:30:08 PM
 User: Melanie Fauteux

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	AFT BLADE FOLD ASSEMBLY
Job Number :	45649		
Estimate Number :	13532		
P.O. Number :		Part Number :	PB674300103
This Issue :	09/02/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	B6743001 P.1,3,4,15
First Issue :	1/1	Project Number :	N/A
Previous Run :	45648	Drawing Revision :	B1
	Type :	Material :	
	SMALL /MED FAB	Due Date :	15/04/2009
Written By :		Qty:	2
Checked & Approved By :	<u>MF 09-03-10</u>	Um:	Each
Comment :	Est Rev:A 08-07-30 new issue DD verified by:ec Est Rev:B 08-12-04 up date part list DD Verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PB674300109	Aft Blade Fold Assembly Weldment

Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Aft Blade Fold Assembly Weldment
 batch: B45044



MF 09-04-07 2

2.0	PB674300113	Aft Adjustable Blade Support Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Aft Adjustable Blade Support Assembly
 batch: B45042



MF 09-04-07 2

3.0	PB674300117	Aft Adjustable Blade Support Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Aft Adjustable Blade Support Assembly
 batch: B45040



MF 09-04-07 2

4.0	PB674300121	PB67-43001-21
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 PB67-43001-21
 batch: 45038



MF 09-04-07 2

5.0	PB674300123	PB67-43001-23
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 PB67-43001-23
 batch: 45035



MF 09-04-07 2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 09/02/2009 4:30:09 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 45649

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PB674300137

PB67-43001-37



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

PB67-43001-37

batch: 0150 29

MF 09-04-07

7.0

PB674300157

Stabilizer Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Stabilizer Arm

batch: 45025

MF 09-04-07

8.0

PB674300159

PB67-43001-59



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

PB67-43001-59

batch: 45024

MF 09-04-07

9.0

PB674300163

Handle Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Handle Assembly

batch: 45023

MF 09-04-07

10.0

PB6743001135

Male Eye



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Male Eye

batch: 239954

MF 09-04-07

11.0

PB6743001155

Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pin

batch: 40517

MF 09-04-07

12.0

PB6743001261

Lever Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Lever Arm

batch: 644978

MF 09-04-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 09/02/2009 4:30:09 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 45649

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PB6743001265

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

batch: 44977 x 4, 46932 x 4

MF 09-04-07

14.0

PB6743001299

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bushing

batch: 43094

MF 09-04-07

15.0

PB6743001305

Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bearing

batch: 41886

MF 09-04-07

16.0

D3451045

Handle and Lock-Down Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Handle and Lock-Down Assembly

batch: 45309

MF 09-04-07

17.0

D3451043

Handle and Lock-Down Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Handle and Lock-Down Assembly

batch: 45308

MF 09-04-07

18.0

D34401

Tube Guide (Supersedes B67-43001-25/-307)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Tube Guide

batch: 41347

MF 09-04-07

19.0

D34403

Clamp (Supersedes B67-43001-309)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Clamp

batch: 41277

MF 09-04-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 45649

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

D34441

Velcro Loop Belt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Velcro Loop Belt

batch: 41349

mf 09-04-09

21.0

D34491

Pad



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pad

batch: 45257

mf 09-04-09

22.0

D34479

Swing Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Swing Arm

batch: B39968

mf 09-04-09

23.0

086004

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Inventory

batch: m109350

mf 09-04-09

24.0

MS27039107

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: 18106

mf 09-04-09

25.0

MS27039123

SCREW



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

SCREW

batch: 108057

mf 09-04-09

26.0

MS21042L4

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total : 26.0000 Each(s)

Nut

batch: m109282

mf 09-04-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Date: • Monday, 09/02/2009 4:30:09 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 45649

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

MS21042L6

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

batch: 108183

mf 09-04-09

28.0

MS518596

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

WASHER

batch: m108986

mf 09-04-09

29.0

MS518598

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

WASHER

batch: m108987

mf 09-04-09

30.0

NAS43DD368

SPACER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

SPACER

batch: m110983

mf 09-04-09

31.0

NAS1149F0316P

WASHER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

batch: m111124

mf 09-04-09

32.0

NAS1149F0432P

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

Washer

batch: m18057

mf 09-04-09

33.0

NAS1149F0632P

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

WASHER

batch: m18057

mf 09-04-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 09/02/2009 4:30:09 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 45649

Part Number: PB674300103

Job Number:



Seq. #:	Machine Or Operation:	Description :
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34.0	NAS1149F0832P	WASHER
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

batch: M18057

mf 09-04-09

35.0	AN960JD6	Washer
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Comment: Qty.: ~~5~~ 1.0000 Each(s)/Unit Total : ¹⁰ 2.0000 Each(s)

Washer

batch: 6085

mf 09-04-09

36.0	AN410A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

batch: M107178

mf 09-04-09

37.0	AN413A	Bolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: M110552

mf 09-04-09

38.0	AN416A	Bolt
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

batch: M110399
or AN415A (see engineering)

mf 09-04-09

39.0	AN611A	BOLT
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

batch: M105558

mf 09-04-09

40.0	AN620A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

batch: M11119
or AN616A (see engineering)

mf 09-04-09

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 09/02/2009 4:30:09 PM
Uspr: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 45649

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

41.0

AN813A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

batch: m110915

mf 09-04-09

42.0

BSP43

RIVET



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

RIVET

batch: m109119

mf 09-04-09

43.0

CR3213405

cherry rivet



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

cherry rivet

batch: m104214

mf 09-04-09

44.0

MS17984C413

PIN, QUICK RELEASE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

PIN, QUICK RELEASE

batch: MS17984C410 (see engineering) batch: m109739

mf 09-04-09

45.0

MS17984C418

PIN, QUICK RELEASE



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

PIN, QUICK RELEASE

batch: m111279 x 4, m111060 x 2

mf 09-04-09

46.0

30345T21

LANYARD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

LANYARD

batch: ~~m111077~~ 17828

mf 09-04-09

47.0

30345T24

LANYARDS



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

LANYARDS

batch: m111351

mf 09-04-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 09/02/2009 4:30:09 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 45649

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

48.0

240107

SPRING SLOTTED PIN



Comment: Qty.: 9.0000 Each(s)/Unit Total : 18.0000 Each(s)

SPRING SLOTTED PIN

batch: m111088

mf 09-04-09

49.0

3408A98

DETENT BALL SPRING PLUNG



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

DETENT BALL SPRING PLUNG

batch: m108390

mf 09-04-09

50.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per dwg and use 242 threadlock A/R shown on dwg PB67-43001 page 2.

242 THREADLOCK batch: _____

NEXT
PAGE

mf 09-04-13

51.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/04/09 (x2)

52.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PPP45657

mf 09/04/13 (x2)

53.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/13 (x2)

Job Completion



mf 09-04-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/03/2009 2:26:23 PM
 User: Melanie Fauteux

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	AFT BLADE FOLD ASSEMBLY
Job Number :	45649		
Estimate Number :	13532		
P.O. Number :		Part Number :	PB674300103
This Issue :	10/03/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	B6743001 P.1,3,4,15
First Issue :	09/02/2009	Project Number :	N/A
Previous Run :	45648	Drawing Revision :	B1
	Type :	Material :	
	SMALL /MED FAB	Due Date :	15/04/2009
Written By :		Qty:	2
		Um:	Each
Checked & Approved By :	<i>MF 09-03-10</i>		
Comment :	Est Rev:A 08-07-30 new issue DD verified by:ec Est Rev:B 08-12-04 up date part list DD Verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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50.0	MS24694S102	Screw
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

M14604*MF 09-04-09*

51.0	AN526A	BOLT
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

BOLT

M16057*MF 09-04-09*

52.0	MS518597	Washer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

M11193*MF 09-04-09*

53.0	NAS1149F0532P	WASHER
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

M18057*MF 09-04-09*

54.0	MS21042L5	Nut
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

M109840*MF 09-04-09*

Job Completion



Date: Wednesday, 08/04/2009 7:36:55 AM
 User: Melanie Fauteux

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	AFT BLADE FOLD ASSEMBLY
Job Number :	45649		
Estimate Number :	13532		
P.O. Number :		Part Number :	PB674300103
This Issue :	08/04/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	B6743001 P.1,3,4,15
First Issue :	09/02/2009	Project Number :	N/A
Previous Run :	45648	Drawing Revision :	B1
		Material :	
Written By :		Due Date :	15/04/2009
Checked & Approved By :	MF 09-04-08		
Comment :	Est Rev:A 08-07-30 new issue DD verified by:ec Est Rev:B 08-12-04 up date part list DD Verified by:ec		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

55.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per dwg and use 242 threadlock A/R shown on dwg PB67-43001 page 2.

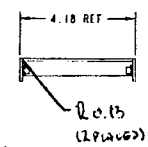
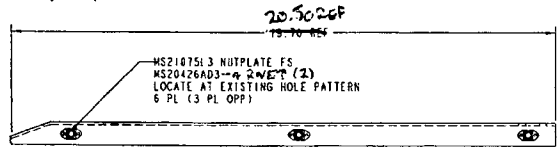
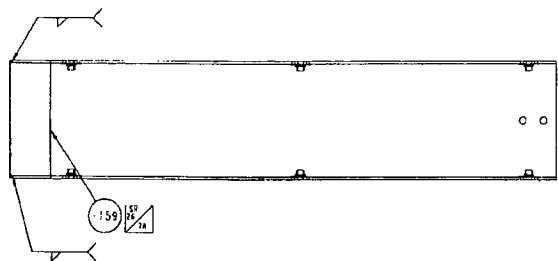
242 THREADLOCK batch: M109681

MF 09-07-09 2

Job Completion

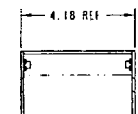
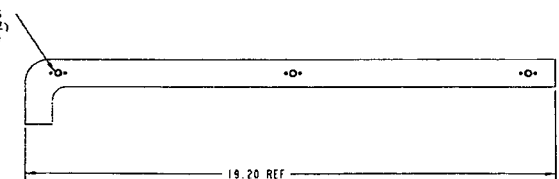
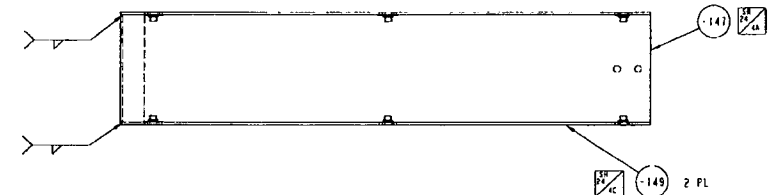


RELEASED



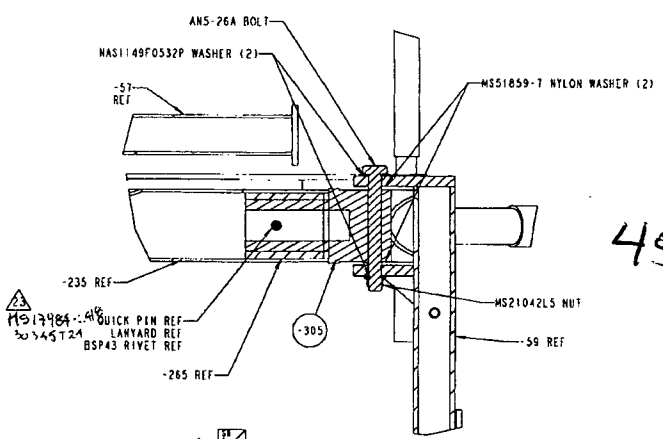
② -71 20 DEGREE BLADE SUPPORT ASSEMBLY

SCALE 0.500



② -67 90 DEGREE BLADE SUPPORT ASSEMBLY

SCALE 0.500



DETAIL A

SCALE 0.750
(-03 ASSY)

45649

PREMIER AVIATION, INC.			
2000 Aviation Parkway, Grand Prairie, Texas 75052			
SIZE	DATE	BY	REV
D	0508	B67-43001	57
SCALE	1:1	SHEET	5 OF 45

ORIGINAL